

Work Order ID 129576

129576

Page 1

February-17-15 9:24:15 AM

Item ID: D2844-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arms
 Start Date: 2/17/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2844	Rev A								

100 NC BRAKE 0.00
 100
 Brake NC Memo 0.00
 Brake NC Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr
 10X ~~DAS~~ ~~28~~ ~~288~~ FEB 23 2015 MAR 03 2015

110 QC5- Inspect part completeness to step on W/O 0.00
 110
 QC Memo 0.00
 Quality Control
 (10) DAS 38 289 MAR 05 2015

120 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00
 120
 Powdercoat Memo 0.00
 Powder Coating
 START TIME: 4:00 FINISH TIME: 1:05 OVEN TEMPERATURE: 135
 25 15-02-05 (X10)

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Item ID: D2844-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arms

Start Date: 2/17/15

Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

73DAS
36
9-8

MAR 23 2015

→ P+0

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

7DAS
38
9-89

MAR 23 2015

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

7DAS
27
9-89

MAR 25 2015

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Item ID: D2844-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arms

Start Date: 2/17/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/06/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 15-03-25*MF*
15-3-25

Picklist Print

Page 1

February-17-15 9:24:14 AM

Work Order ID: 129576

129576

Parent Item: D2844-1

D2844-1

Parent Item Name: Arms

Start Date: 2/17/15

Required Date: 3/06/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B00.11.01 Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased			No	100	f	149.8000	1.8991	20			
										**	DAS	28	MAR 23 2015
											9-89		

M304TR0 500W 035

304 RD Tube .500 x .035W

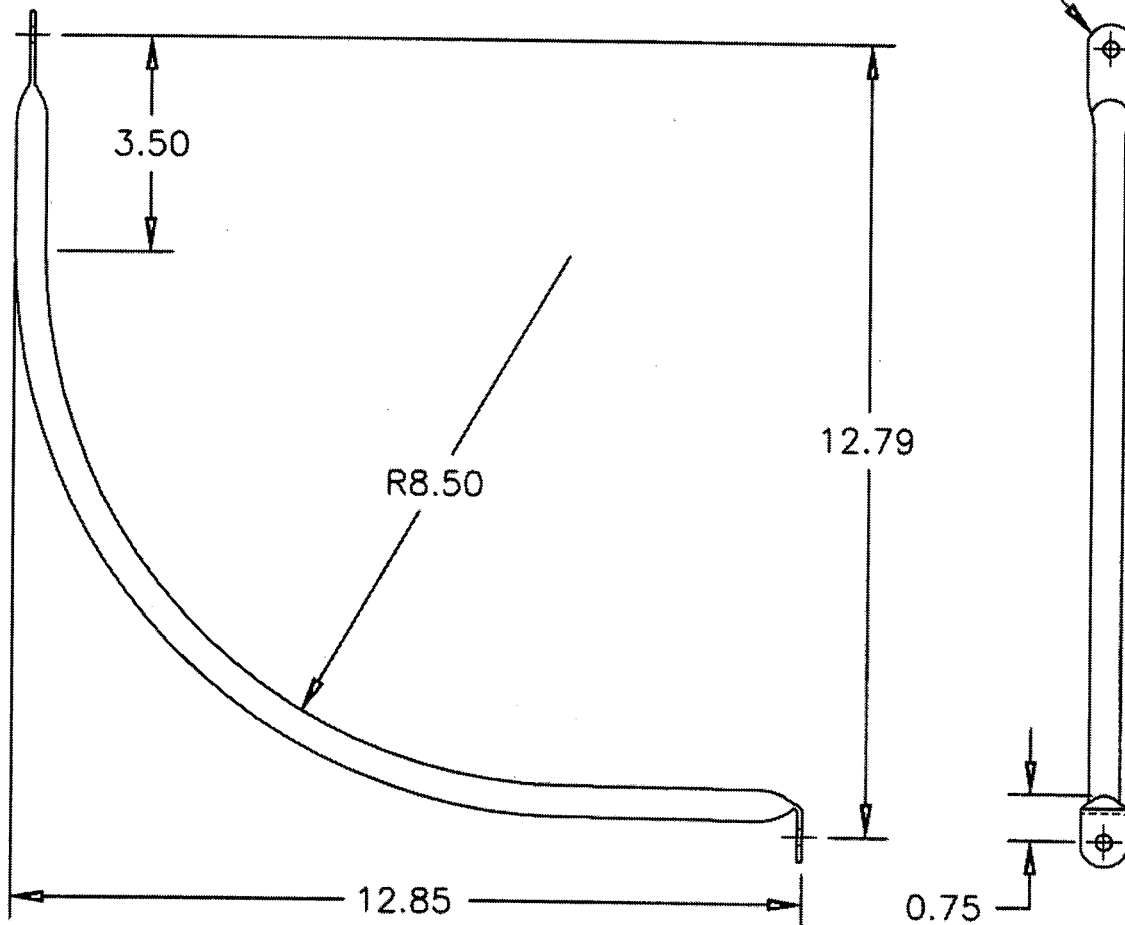
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA002	149.8	
125513	2	
126922	3.5	
m128084	11	
<u>m128495</u>	61	20
m128833	3.8	
m129188	8	
m130292	60.5	619



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

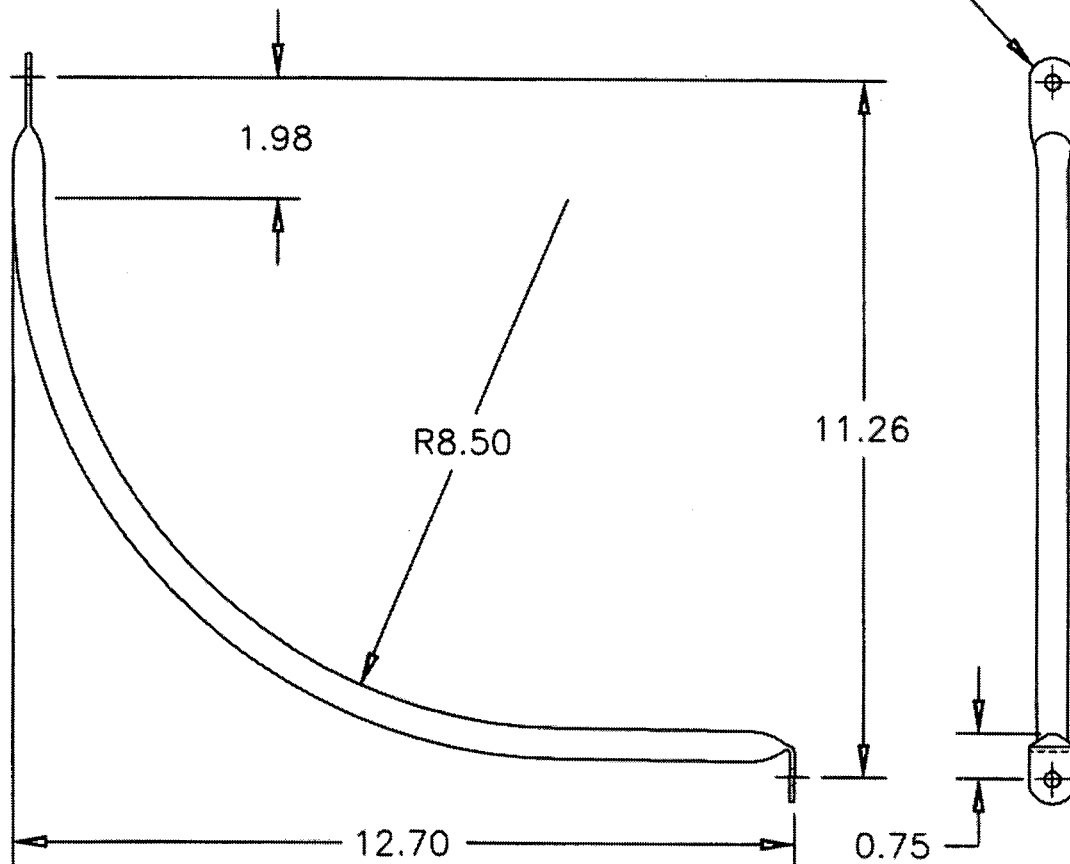
MATERIAL: AISI 304/316 SS TUBE, $\emptyset 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3

RELEASED
18.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL

ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

DQA:

Date:

15/05/16

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

15/05/11

Work Order update only ☐

Work Order: <u>129576</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2844-1</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>15-4934</u>	Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-03-20	130	3	imperfection in paint RC. Operator too much paint	S 15/03/24 a2012	scrap / destroy	15-03-24 MAP 23 2015 DAS 38 9-89	DAS 9 9-89 15-03-23	
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☒ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other